

Work Order ID 147017

Thursday, May 26, 2016 9:16:26 AM

147017

Page 1

Item ID: D212-803-115

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Left Hand Pilot In Command - Slim Design, Complete 212/412

Start Date: 5/26/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: mf Date: 16-5-26 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9728	A								
IIN-D212-803	D								

150

0.00

150

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D212-803-115 X 1 B142105

REMOVE:

MS3120E16-99S X 1 AND RETURN TO STOCK UNDER ORIGINAL
BATCH NUMBER M133107

(NEEDED FOR A KIT SHIPPING TODAY)

REPLACE WHEN AVAILABLE

DAS
27
9-89

NOV 29 2016

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

DAS
28
9-89

NOV 29 2016

DART aerospace				1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 TEL 1-813-637-5200 www.dartaero.com	
PATENT	N/A			CHG	CHG002
P/N	D212-803-115			STC	SR02233SE
DESC.	LH Pilot in Command			STC	
LOT	B142105			STC	
MODEL	Bell 212/412			STC	
TC APPROVAL # 09-89				MADE IN CANADA	
				D2729-4	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 147017***147017***

Page 2

Thursday, May 26, 2016 9:16:26 AM

Item ID: D212-803-115

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Left Hand Pilot In Command - Slim Design, Complete 212/412

Start Date: 5/26/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>Eg007</i>	0.00							
170						<i>SmB</i>			
Packaging	Memo	0.00							NOV 29 2016
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DEC 02 2016

DAS
21
9-09

DEC 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective : 31 07				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Thursday, May 26, 2016 9:16:25 AM

147017

D212-803-115

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-803-115		Manufactured	No				Each	0.0000		1			
D212-803-115 Left Hand Pilot In Command - Slim Design, Complete 212/412													
MS3120E16-99S		Purchased	No				Each	1.0000		1			
MS3120F16-99S Socket													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST			1						
				m133107			1						
MS3120E16-99S		Purchased	No				Each	1.0000		-1			
MS3120F16-99S Socket													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST			1						
				m133107			1						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

List Lots

Page 1 of 1

Thursday, May 26, 2016 8:37:19 AM

Criteria : Item ID: d212-803-115 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D212-803-115 Left Hand Pilot In Command - Slim Design, Complete 212/412	Main Warehouse FG023	142105	5/4/2016	1.0000	QC21	CHG002	

Total: 1.0000

#147017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

LOT TRACKING !!

Reason	Parent Item ID	Lot Qty	Lot Nbr	Avg Cost Amt	Last Cost Amt
141292	MS24523-27	-1	m133990	\$15.03	\$15.03
141292	MS27039-1-07	-1	m127813	\$.08	\$.08
141292	30-037-26	-3	m133270	\$19.50	\$19.50
141292	D4411-7	-1	138557	\$10.18	\$10.27
141292	M39029/31-228	-2	M127949	\$2.48	\$2.52
141292	30-037-3	-2	m128898	\$42.50	\$42.50
141292	51MX5-5-J	-1	m133107	\$615.00	\$615.00
141292	MS21919WDG19	-1	m133988	\$.79	\$.77
141292	MS21044N04	-2	m132677	\$.34	\$.34
141292	MS35206-226	-5	m127831	\$.05	\$.06
141292	MS21919WDG10	-1	m128993	\$.57	\$.54
141292	M39029/32-259	-2	m128795	\$.30	\$.30
141292	MS171599	-1	m129150	\$1.69	\$1.08
141292	M39029/32-259	-19	m134112	\$.30	\$.30
141292	NAS1149D0363J	-2	m133932	\$.02	\$.02
141292	D5049-1	-1	119803	\$7.22	\$7.23
141292	MS21042L3	-1	m134039	\$.14	\$.14
141292	MS3126E16-99P	-1	m128898	\$80.36	\$80.36
141292	MS3126E16-99P	-1	m133107	\$80.36	\$80.36
141292	MS3120E16-99S	-1	m133107	\$105.00	\$105.00
141292	MS3373-A1	-3	m132700	\$3.08	\$3.08
141292	MS24693-S7	-2	m129278	\$.15	\$.15
141292	D5055-9	-1	139497	\$9.85	\$9.85
141292	D5055-5	-1	139477	\$9.85	\$9.85
141292	MS27212-1-3	-1	M127977	\$6.75	\$6.50
141292	M39029/31-240	-21	m134112	\$.40	\$.40
141292	27ET51-T	-1	m131455	\$1,390.43	\$1,300.00
141292	M39029/32-247	-2	M127949	\$1.25	\$.85
141292	D5055-3	-1	139609	\$10.63	\$10.63
141292	MS21042L06	-3	m133363	\$.17	\$.15
141292	D5055-7	-1	139620	\$9.85	\$9.85
141292	D5046-043	-1	129628	\$348.29	\$348.29
141292	AN961-6T	-3	123314	\$.30	\$.30
141292	NAS1197-6	-5	m128976	\$.12	\$.09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 147017

Thursday, May 26, 2016 9:16:26 AM

147017

Page 1

Item ID: D212-803-115 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Left Hand Pilot In Command - Slim Design, Complete 212/412
Start Date: 5/26/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/10/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MF Date: 16-5-26 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9728	A								
IIN-D212-803	D								
150		0.00							
150									
Packaging	Memo	0.00							
Packaging	PULL FROM STOCK D212-803-115 X 1 B142105								
	REMOVE: MS3120E16-99S X 1 AND RETURN TO STOCK UNDER ORIGINAL BATCH NUMBER M133107								
	(NEEDED FOR A KIT SHIPPING TODAY)								
	REPLACE WHEN AVAILABLE								
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

CH6002 or CH6005

DAS
21
9-89

DEC 01 2016

DAS
27
9-89

NOV 29 2016

DAS
28
9-89

NOV 29 2016